Work Orde	er ID 98336 47:34 PM		*983	36*						Page 1	
Revision ID:	D3255-042 Access Panel Assembly	,	Accept	*N900	040	100)*	Setup St	. 1 1	S1* S2*	
Start Date: Required Date: Reference:	3/11/13 Start Qty: 3.0 3/22/13 Req'd Qty: 3.0	/7* . /	1	Cust Item Customer:			•				
Approvals:	Process Plan: MLJ	Date: /3-03-/	7 Tooling:	D	ate:	=	I			R1*	
••	QC:	Date:	SPC (Y/N):	D	ate:			S	top *N	R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3255	Rev B									13-04	برا
100			0.00				11				,
100	Large Fab		0.00				4				
Large Fab Large Fab	Memo 1-Weld Batch:	d as per Dwg D3255 ***purge	0.00 e weld***A/R SS ROD Welds Flush								
110	QC10- Inspect visi	ual per QSI004- ground welds	0.00							6.	
110							B	12	PC-100-2	DAG	
QC	Memo	0	0.00						J	0-89	
Quality Control									•		
										•	
120	QC5- Inspect part	completeness to step on W/O	0.00							DAS 09 8	
120		•					(4)) _\^2	MG-140-C	09	
QC	Memo	0	0.00							(a-0)	

Quality Control

NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	•
_		

NCN.	163	, 140				WORK ONDER HOW				QA Closed:	Date	::
Work Orde	or:					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIG	- · ·				<u></u>	Rework	Skid-tube	Crosstube	tube Water Jet Engineering			
Part N	Vo.					Scrap	† 	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	The	rmoforming	Finishing	-4	re/Packaging	Other
NCR I	Vo.					Work Order Update]	Large Fab	Composite]	Supplier	
								·····				
Root						ption of work order update	Initial	i	ction	Sign &	_	
Cause		Date	Step	Qty	(or Non-conformance	Chief Er	ng Des	scription	Date	Verification	QC Inspector
Doc/Data	Ш											
Equip/Tooling												
Operator												
Material	Ш											
Setup	Ш						-			•		
Other _.	Ш											
Process												1
Supplier	Ш									•		·
Training	Ш											
Unapproved							<u> </u>			<u></u>		
						····	AULT CA	regory				
Landi	_				_	General				1	_	-
	Н.	Bending			<u> </u>	Bend	Grain		<u> </u>	Ovalized	. -	Pressure/Forced
	\vdash	entre No	ot Concer	ntric to	o/s	BOM/Route	Hard		<u> </u>	Over/Under		Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged		ction Incomplete	_	Part Incorre		Weld
	\vdash	crushed/0	Crimped.			Burrs	─ ─	uctions Incomplete	e/Unclear	Part Lost/M	_	Wrong Stock Pulled
	\square^{c}	Cuffs				Contamination	$\boldsymbol{\vdash}$	ntenance	·	Part Moved		
	Ш⁺	leat Trea	t ·		<u> </u>	Countersink	\vdash	beled	<u></u>	Positioned \	_	_
	<u></u> Ш'	nspection	Strip in	Tube	<u> </u>	Cut Too Short	Misro	ead		Power Loss,	/Surge	Other
	L R	lipples in	Bend		. <u>L</u>	Drill Holes	Offse	t				
	Шт	orque W	aves in E	xtrusio	n 🗀	Drawing	Out	of Calibration				
	П	urning Se	equence		. [Finish	Out of Sequence					
			Folio	Outs	ide Dimensions							

Work Order ID 98 March-12-13 1:47:34 PM	8336		*983		Page 2				
Item ID: D3255-042 Revision ID: Item Name: Access Pane	. '		Accept	*N900040)100* Setu	p Start Stop	*NS1* *NS2*		
Start Date: 3/11/13 Required Date: 3/22/13 Reference:	Start Qty: 3.00 Req'd Qty: 3.00	* 7 *	.4	Cust Item ID: Customer:					
	lan:	Date:		Date:	Run	Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center ID 130 *130* Powdercoat Powder Coating	Operation Description Grey Sandtex(Ref:4.3.5.6 Memo START TIM	E: 13 FINISH TIME:	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE:	Tool ID Tool #			Reject Insp. Number Stamp		
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	<u>.</u>	0.00		<u> 4</u> x	4	11 13/00/24		
*150 *150* Small Fab Small Fab	D3255A/R		0.00 0.00 5-042 using Dow corning adhe: ORNING ADHESIVE	sive as per Dwg	4	· 	Sploy		

NCR:	Yes	1	No

											DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORN	MANCE / UPD	DATE	•				
									•		QA Closed:	Date:			
Nork Ord	er.					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part	Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Therm	~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
New	10.					Work Order opaute]		zarge ras	composite_	<u></u>		·		
Root Cause		Date	Step	Qty	Des	otion of work order update or Non-conformance	t	nitial iief Eng	Acti Descri		Sign & Date	Verification	QC Inspector		
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining			9.00			,		0							
						FA	AUL	T CATE	GORY						
Landi		1				 General					Ovalized		Pressure/Forced		
	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Bend BoM/Route Broken/Damaged Cutrosentamination Countersink Cut Too Short Drill Holes					Hardwa Inspecti Instruct Mainte Mislabe	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			tolerance ct sssing Vrong Surge	Temperature/Cure Weld Wrong Stock Pulled Other				
		Torque W		xtrusio	n	Drawing	Out of Calibration								
		Turning Se Wave/Twi				Finish Folio	Out of Sequence Outside Dimensions								

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 98336 Page 3 March-12-13 1:47:34 PM *N900040100* Setup Start D3255-042 Accept Item ID: **Revision ID:** Stop Access Panel Assembly **Item Name: Start Date:** 3/11/13 Start Qty: 3.00 **Cust Item ID:** Required Date: 3/22/13 Req'd Qty: 3.00 **Customer:** Reference: Run **Tooling:** Date: Process Plan: Date: Approvals: Stop SPC (Y/N): Date: QC:_____ Date: Reject Set Up/ Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Insp. Number Stamp Qty Code **Qty** Work Center ID Description **Run Hours** 0.00 160 QC5- Inspect part completeness to step on W/O *160* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 0.00 170 *170* 8176 0.00 Packaging Memo Packaging OC21- Final Inspection - Work Order Release 0.00 180

0.00

Memo

QC

Quality Control .

mr 4-29

											DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-	100	NFORN	MANCE / UP	DATE	Q	A Closed:	Date:	
Work Orde	or:				DISPOSITION				AGAINST D	EPA	ARTMENT/	PROCESS	
Part I	No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Π	Initial	Ac	tion		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
					F	AUL	T CATE	GORY					
Landi	Cracks Crushed Cuffs Heat Tre	Not Conce /Crimped)/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		-1 '	on Incomplete ions Incomplete/ nance led	Unclear	P P P	Ovalized Over/Under art Incorrect art Lost/Mi art Moved ositioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples	in Bend			Drill Holes	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

98336

Parent Item:

D3255-042

Parent Item Name: Access Panel Assembly

Start Date: 3/11/13

Required Date: 3/22/13

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2		Manufactured	No		bound	100	Each	0.0000	1	77 3			13-04
anel 9 3255-3 ap		Manufactured	No		\$18415)	150	Each	4.0000	1	1 3			In
ар				Location WAOD	98272	Loc Oty 2	<u>Lo</u>	c Code	5	4)	F	•	THE
				WA002	3201	2 2 2					'		
3255-5 asket		Manufactured	No			100	Each	4.0000	1	3			13-04
				Location		Loc Qty	<u>Lo</u>	c Code				_	
					72118 75083	4 1 1		u.				≯ 1	310412
				. 9	16137 18928	2			2				ì

NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE									
		QA Closed:								
Work Order:	DISPOSITION	AGAINST DEPARTMENT/								
work Order.	Rework	Skid-tube Crosstube								
Part No.	Scrap	Machining Small Fab Prod								

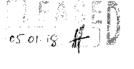
Work Order:			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No	Part No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	t .	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				•				;			*.	
опаррточец		<u> </u>		l	F.	AUL	T CATE	GORY			<u> </u>	•
Landing	Gear				General							
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W Turning S	Crimped at n Strip in n Bend Vaves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of (ion Incomplete tions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tuł	oe -		Folio		Outside	Dimensions				

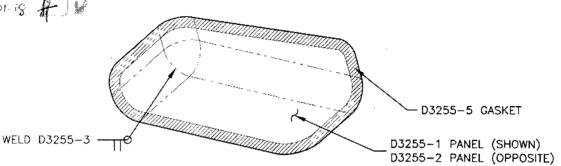
Date:

Date:

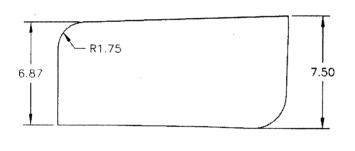


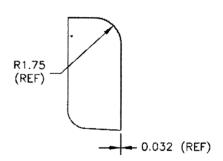
DESIG	N T	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	ŒD , O	APPROVED	DRAWING NO. REV. B
	W	- H-	D3255 SHEET 1 OF 4
DATE			TITLE SCALE
04.1	2.06		ACCESS PANEL ASSEMBLY 1:6
A		04.01.27	NEW ISSUE
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098

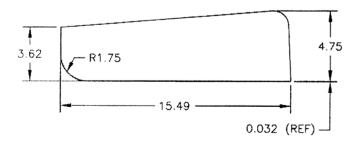




D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)







13-03-14 13-03-14

D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:

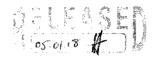
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

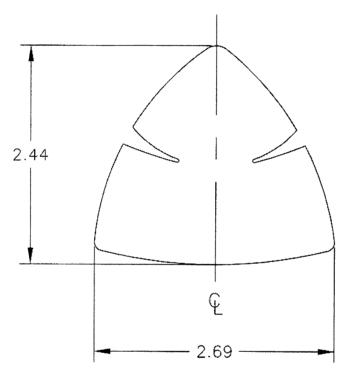
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CHECKED	APPROVED	DRAWING NO.	REV. B		
1 4	TN	D3255	SHEET 2 OF 4		
DATE		TITLE	SCALE		
04.12.06		TITLE	1:1		





D3255-3 CAP FORM TO FIT D3155-1/-2

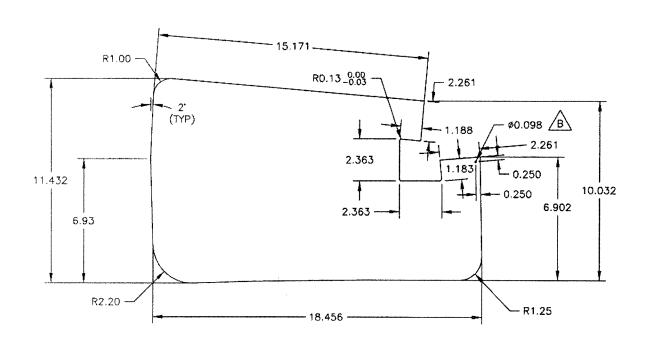
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



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CHECKED (APPROVED	drawing no. D3255	REV. B SHEET 3 OF 4	
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:5	





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

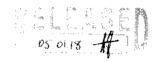
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

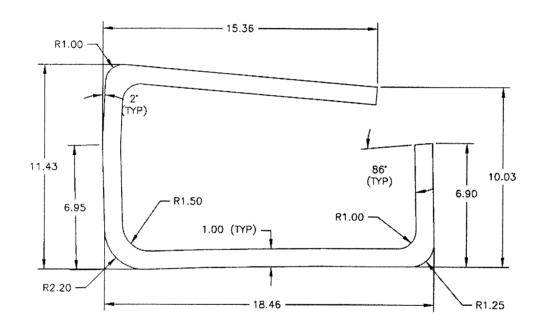
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DATE	1.4	TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:5	





D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES